

Date: Friday, 01/05/2009 11:20:02 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 47649					
Estimate Number	: 10725					
P.O. Number	:			Part Number	: D2652	
This Issue	: 01/05/2009		S.O. No. :	Drawing Number	: D2652 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	MACHINED PARTS	Drawing Revision	: A
Previous Run	: 46608			Material	:	
Written By	:			Due Date	: 10/05/2009	
Checked & Approved By	: <u>JULIA M. LACELLE</u>			Qty:	300	Um: Each
Comment	: Est Rev:B 02.06.13 Now machined in house.			NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0500	303 Round Bar 0.500"	
		.0578 P(s) Unit 17.925 P(s)	
		Comment: Qty: 0.0578 P(s) Unit Total: 17.9250 P(s) Material: 303 ss .500" Round Bar (M303R0500) Batch: M111448	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652	
		FOLIO REV: <u>A</u> DWG REV: <u>A</u>	
		2-DEBURR AS REQUIRED	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	304
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	304
4.0	QC8	SECOND CHECK	304
		Comment: SECOND CHECK	304
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: ST46	
		88 09/05/11 X304	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:20:02 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 47649

Part Number: D2652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	470A
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article Prototype

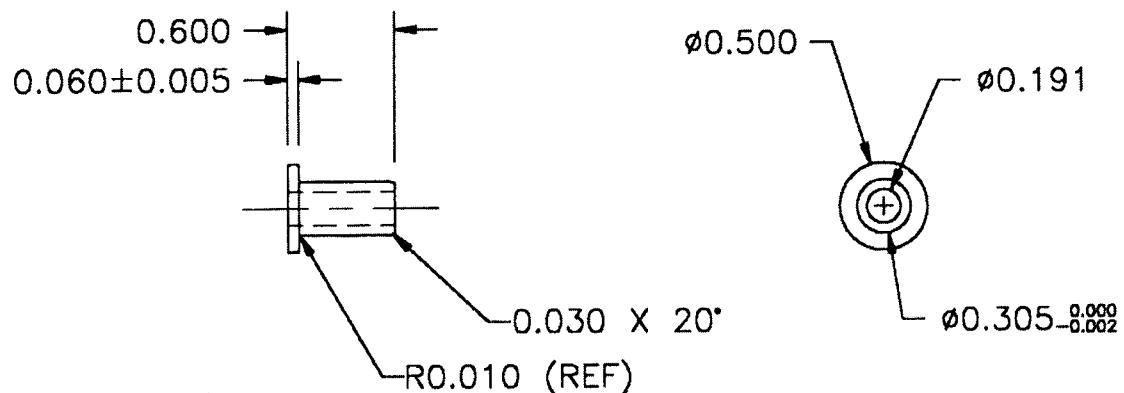
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/05/06	Date:	09/05/06	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	TT



DESIGN <i>MW</i>	DRAWN BY <i>MW</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>BWS</i>	APPROVED <i>MW</i>	DRAWING NO. D2652 REV. A SHEET 1 OF 1
DATE 97:03:25	TITLE BUSHING	SCALE 1:1

RELEASED  
97/04/25 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 167069

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED